Quality Control

Work Order ID 123415 *123415* Page 1 Thursday, August 07, 2014 11:15:02 AM Accept D3535-25 *N900040100* Setup Start Item ID: **Revision ID:** Stop Wearplate Center **Item Name: Start Qty: 12.00 Cust Item ID: Start Date:** 8/07/14 Required Date: 8/07/14 Req'd Oty: 12.00 **Customer:** Reference: Start Run Date: 14-08-08 Tooling: Date: Approvals: Stop QC: Date: SPC (Y/N): Date: Tool # Plan Reject Reject Operation Set Up/ Tool ID Accept Insp. Sequence ID/ Code Qty Oty Number Stamp **Work Center ID** Description **Run Hours Draw Nbr Revision Nbr** D3535 Rev B DAS 0.00 100 FLOW WATER JET 14/08/20 *100* 0.00 Waterjet Memo 1-Cut as per Dwg D3535 Dwg Rev: 1 Prog Rev: B FLOW CNC Waterjet Deburr if necessary 304/316,040 DAS 0.00 QC2- Inspect parts off machine FAI/FAIB 110 *110* 0.00 Memo **Quality Control** DAS 0.00 120 QC8- Inspect parts - second check *120* 0.00 OC Memo

Work Order: 172415 Part No. 03535-25 Rework Scrap Machining Small Fab Prod. Eng. Coor. Qua Machining Small Fab Composite Suspected Unapproved Large Fab Composite Supplier Root Cause Date Step Qty Or non-conformance Chief Eng Description Date Verification QC Ins Design Doc/Data Equip/Tooling X Handling/Pre Material Operator Offset/Setup X 14/08/11 Offset/Setup X 14/08/11 For Machining Small Fab Prod. Eng. Coor. Qua Machining Small Fab Prod. Eng. Coor. Qua Rec/Store/Packaging Small Fab Description Other Supplier Other Fab Description of work order update Initial Action Description Date Verification QC Ins Date Prod. The machine Pr	DQA: Date: 14/12/08 QA Closed: Date: 14/12/	/ UPDATE Work Order update only
Scrap Machining Small Fab Prod. Eng. Coor. Qua Use-as-is Suspected Unapproved Use-as-is Composite Suspected Unapproved Use-as-is Composite Suspected Unapproved Use-as-is Composite Suspected Unapproved Use-as-is Composite C	700	
Cause Date Step Qty or non-conformance Chief Eng Description Date Verification QC Ins Design Doc/Data Equip/Tooling & A bug in the washright System. Equip/Tooling & Handling/Pre Material Operator Offset/Setup W 14/08/11 DAS 16 9-89 Material Operator Offset/Setup W 14/08/11 DAS 16 9-89 CAURI LAN. To be zircord. Offset/Setup W 14/08/11 DAS Schwill Meinter Reaming (19/08/12) FAULT CATEGORY DAS 16 9-89 Have Machine Reaming (19/08/12) FAULT CATEGORY		Small Fab Prod. Eng. Coor. Quality Sinishing Rec/Store/Packaging Other
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Centre Not Concentric BOM/Route Grain Over/Under tolerance Set-up Cracks Broken/Damage/Defect Hardware Part Incorrect Temperatu Crimp/Kink/Ripple/Wave Burrs Inspection Incomplete/Unqualified Part Lost/Missing Weld	Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence	Over/Under tolerance Part Incorrect Temperature/Cure Weld ete/Unclear Part Moved Positioned Wrong Power Loss/Surge Over/Under tolerance Temperature/Cure Weld Wrong Stock Pulled

Work Order ID 123415

Powder Coating

123415

Page 2

Thursday, August 07, 2014 11:15:02 AM Accept D3535-25 *N900040100* Setup Start Item ID: **Revision ID:** Stop Wearplate Center **Item Name:** *12* **Start Oty: 12.00 Start Date:** 8/07/14 **Cust Item ID:** Required Date: 8/07/14 Req'd Qty: 12.00 *19* **Customer:** Reference: Start Run Process Plan: Date: **Tooling:** Date: Approvals: Stop Date: SPC (Y/N): Date: OC: Reject Sequence ID/ **Tool ID** Tool # Plan Accept Reject Insp. Set Up/ Operation Code Qty Qty Number Stamp **Work Center ID Description Run Hours** 0.00 130 DAS NC BRAKE *120* 30 0.00 9-89 Brake NC Memo 1-Form on CNC Brake as per Dwg D3535 using Jigs DT8261and DT83262-Brake NC Form joggle on Punch as per Dwg D3535 using Jig DT8158Identify as D3535-25 OC5- Inspect part completeness to step on W/O 0.00 140 *110* 0.00 OC Memo Quality Control 24-6 14-9-3 358 Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 0.00 150 *150* 0.00 Powdercoat Memo

OVENEEMPERATURE:

FINISH TIME:

DQA:			Date:			•			•	•			•	TRAG [*]
						WORK ORDER NON	-CC	ONFO	RMANCE / UP				_	AEROSPACE
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Page 3

Thursday, Augu				^ I Z.	3415^							rage	<i>3</i>
Item ID: Revision ID:	D3535-25			Accept	*N900	040	100)*	Setup	Start	*N	S1*	
Item Name:	Wearplate Ce	nter								Stop	*N	S2*	
Start Date: Required Date:	8/07/14 8/07/14	Start Qty: 12.00 Req'd Qty: 12.00	*1 <i>2</i> * *1 <i>2</i> *		Cust Item I Customer:	D:							
Reference:													
Approvals:	Process Pla	an:	Date:	Tooling:	Da	ate:			Run	Start	*N	R1*	
	QC:		Date:	SPC (Y/N):	Da	ate:				Stop	*N	R2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp	
160		QC3- Inspect Part Finish		0.00							_	/ /	
160 QC Quality Control		Мето		0.00				24	<i>D</i>	. E		14 <i>09/</i> 0	3
170		Identify as per dwg & Sto	ck Location: <u>FP-0</u> 0	2 0.00					1	1	no 1	1	1
170 Packaging Packaging		Memo		0.00				XC	<u> </u>	ф.	<u>IL</u>	14/09	16
180		QC21- Final Inspection -	Work Order Release	0.00									
1 AO QC Quality Control		Мето		0.00					162		170	3-04 - 4-9-0	B
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DQA:			Date:				DART								
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		Inspectio	n Strip in	Tube		Drawing		Misread	d						
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		 Turning S				Finish		Out of 0	Calibration						
		Wave/Tw				Fit/Function		Out of 9	Sequence						

Thursday, August 07, 2014 11:15:02 AM

Work Order ID: 123415

123415

Parent Item:

D3535-25

D3535-25

Parent Item Name: Wearplate Center

Start Date: 8/07/14

Required Date: 8/07/14

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A New Issue 07-02-15 JLM

IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No		100	sf	290.2519	0.51	13	DAS		/
M304S20 304/316 .040 Sheet)GA							**		46 9-89	De	14/08/20

Location	Loc Qty	Loc Code	
MAT020	290.2518948		
m126852	0.31		
m127454	26.1018948		
m128435	117.14		<u> </u>
m129128	6.5		
m129530	10.2		
m129845	130		<u>8.6</u>

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						DISPOSITION				AGAINST D	EPARTMENT	/PROCESS		
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Root					Desc	ription of work order update	-1	nitial	Act	ion	Sign &	·		
Cause	ı	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector	
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		Centre N	ot Concer	ntric		BOM/Route	┌	Grain			Over/Under	tolerance	Set-up	
	П	Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorred	ci	Temperature/Cure	
		Crimp/Kiı	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Ur	qualified	Part Lost/Mi	ssing	Weld	
	\vdash	Cuffs	,			Contamination		Instruct	ions Incomplete/L	Inclear	Part Moved		Wrong Stock Pulled	
	-	Crushing				Countersink		Misalig	ned/off center	Γ	Positioned V	Vrong		
	-	Heat Trea				Cut Too Short		Mislabe		Γ	Power Loss/	Surge	Other	
	_	Inspectio		Tube		Drawing		Misread	d -	_		_		
	-	Marks/Ch	•			Drill Holes		Off-set		•	· · ·			
		•	Sequence			Finish		4	Calibration	-				
		•	vist in Tub			Fit/Function		Out of	Sequence					

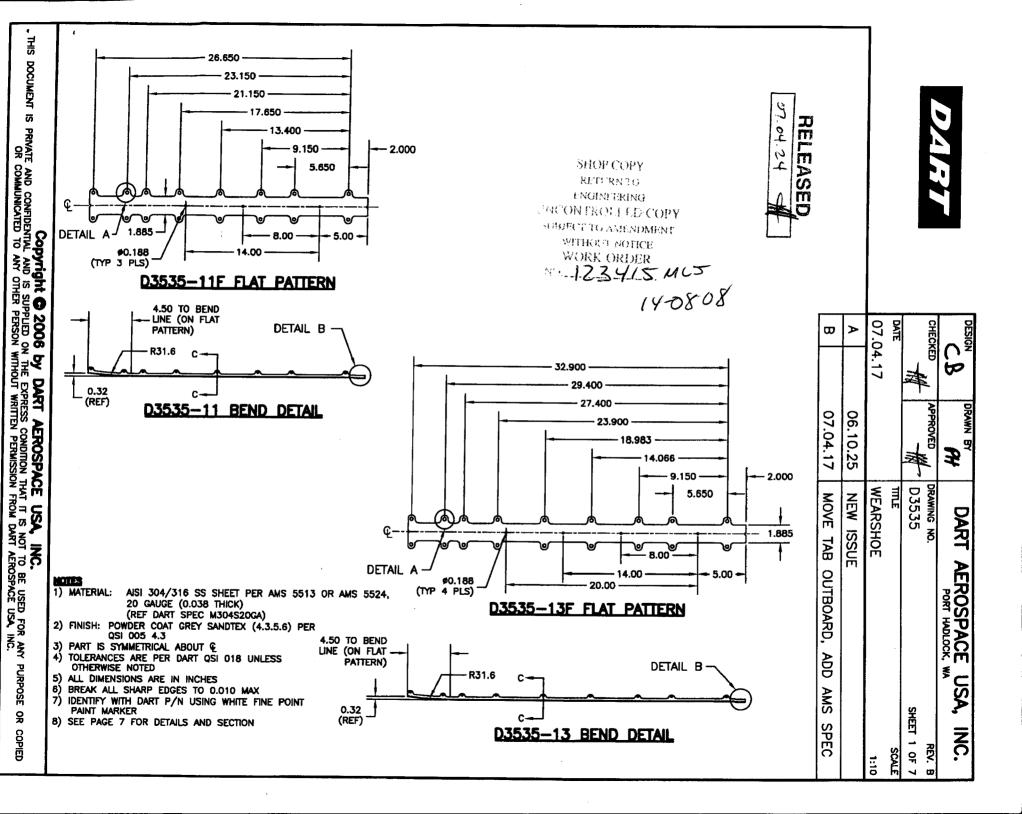
DART AEROSPACE LTD	Work Order:	123415
Decoriation: Western		
Description: Wearshoe	Part Number:	D3535-25
Inspection Dwg: D3535 Rev: B		Page 1 of 1

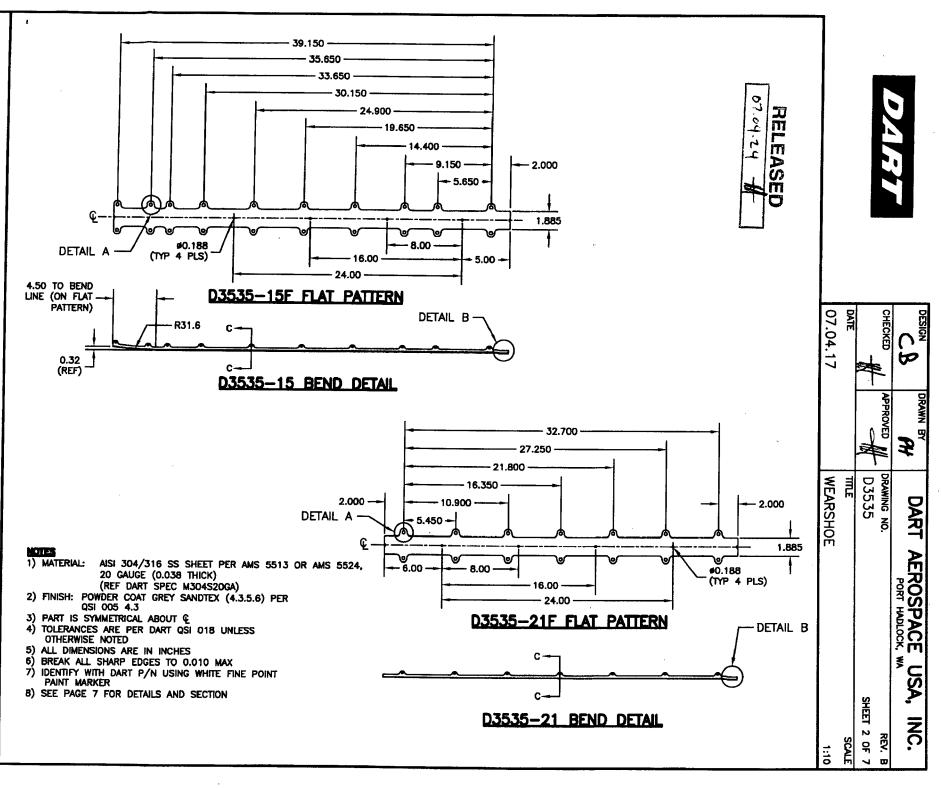
FIRST ARTICLE INSPECTION CHECKLIST

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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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1.450	+/-0.010	1.450	/			
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10.900	+/-0.010	10.900	/			-
16.350	+/-0.010	16.350				
21.800	+/-0.010	21.800	1/			
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_ A	07.11.23	New Issue	Revised by	Approved
			KJ/EC/DD	





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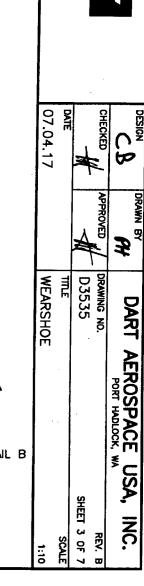
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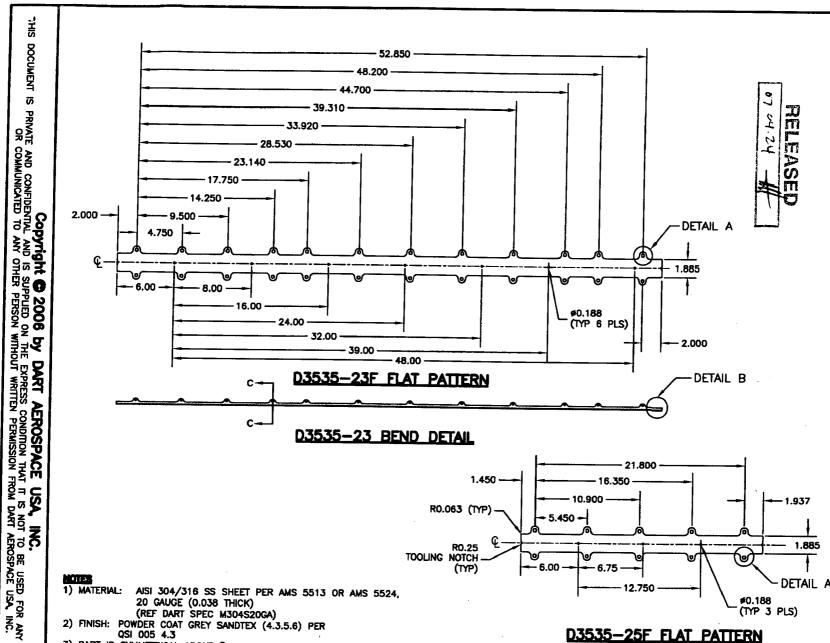
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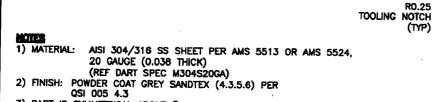
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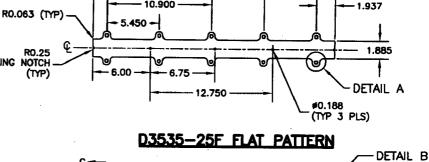
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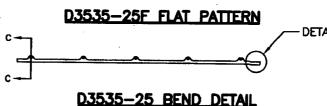
5) ALL DIMENSIONS ARE IN INCHES

6) BREAK ALL SHARP EDGES TO 0.010 MAX

7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER

8) SEE PAGE 7 FOR DETAILS AND SECTION





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D3535-31F FLAT PATTERN

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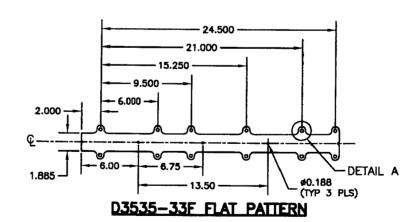
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D3535-31 BEND DETAIL





1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)

QSI GAGGE (0.556 THICK)

(REF DART SPEC M304S20GA)

2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3

3) PART IS SYMMETRICAL ABOUT &

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

6) BREAK ALL SHARP EDGES TO 0.010 MAX
7) IDENTIFY WITH DART P/N USING WHITE FINE POINT

PAINT MARKER 8) SEE PAGE 7 FOR DETAILS AND SECTION

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D3535-35F FLAT PATTERN



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PURPOSE

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AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)

(REF DART SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3

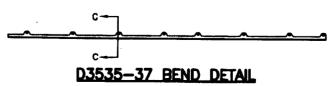
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ALL DIMENSIONS ARE IN INCHES

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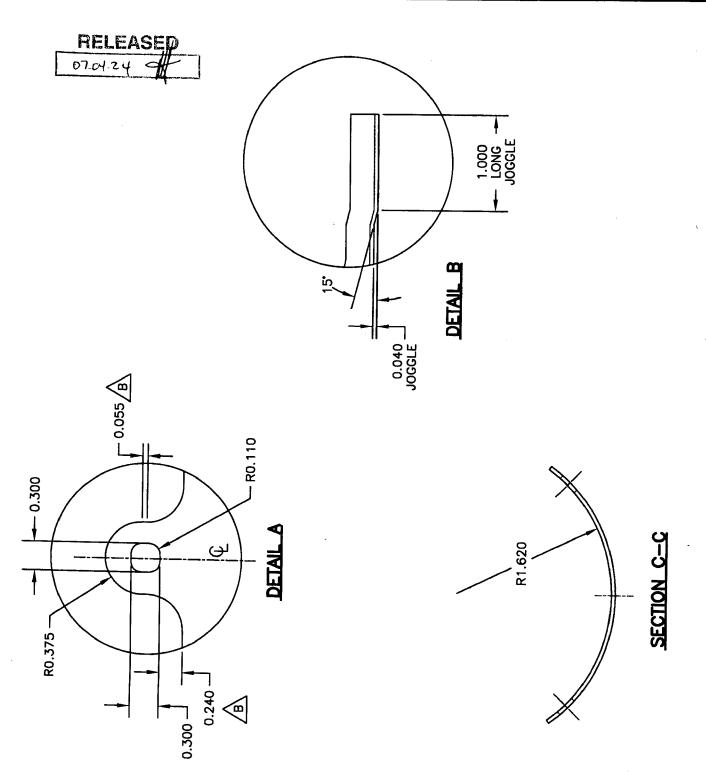
IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER

8) SEE PAGE 7 FOR DETAILS AND SECTION





DESIGN	DRAWN BY	DART	AEROSPACE USA, INC.
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3535	SHEET 7 OF 7
DATE		TITLE	SCALE
07.04.17		WEARSHOE	1:1



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